

Date: Monday, 3/6/2006 1:55:41 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW KIT (19"X24")
<b>Job Number</b> : 26076	
<b>Estimate Number</b> : 10323	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : K10008
<b>This Issue</b> : 3/6/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2432 REV F3
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F3
<b>Previous Run</b> : 25767	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 3/20/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>DA 06/03/06</u>	
<b>Comment</b> : Est Rev:J 04.02.17 Blank size changed KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D427-659-011

D315-670-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

DA 06/03/06

10

2.0

MUHMWB10

UHMW 1" Black

**Comment:** Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch: M 100501 16pc M 100417 4pc

JF 06/03/30 10

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

JF 06/03/31 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*mf 06/04/01*

10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*EP 06/04/02*

10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 25.0000 f(s)  
Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion *B23172 6mlr*

*B24870 54mlr*

10

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block *B24872 12mlr*

2 D2432F(ref only) Bearpaw *B26076*

*B25769 108mlr*

10

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp *B25015 54mlr*

*B23818 6mlr*

10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B23177 12mc

B 25372 ~~10000~~ 96 112X B26485 ✓

11.0

D2732

Rubber Extrusion



Comment: Qty.: 2.5000 f(s)/Unit Total : 25.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

B24182 53mc

B26472 7mc ✓

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M19085 42mc ✓

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M15432 12mc ✓

M19491 108mc

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M19085 216mc ✓

M19085 24mc

18431

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/05/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M17957 12mcp 108mcp M19099 R4/8/3 (10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206104/04 inspect 8 kit

(+2)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: \_\_\_\_\_

REV.E

100/5/9

(10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/10

Job Completion



06-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	26076
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0,063"				
B	5.500	+/-0.030	5,497"				
C	0.200	+/-0.030	,192"				
D	0.25 x 45°	+/-0.030	,255"				
E	R0.250	+/-0.030	R,250"				
F	0.250	+/-0.010	,240"				
G	0.625	+/-0.030	,622"				
H	0.375	+/-0.010	,371"				
I	0.950	+0.030/0.010	,949"				
J	19.000	+/-0.030	19,000"				
K	3.14	+/-0.030	3,140"				
L	3.28	+/-0.030	3,310"				
M	Ø0.260	+0.005/-0.000	,260"Ø				
N	Ø0.93	+/-0.030	,926"				
O	0.30	+0.030/-0.000	,300"				
P	23.750	+/-0.030	23,750"				
Q	7.375	+/-0.030	7,375"				
R	4.250	+/-0.010	4,252"				
S	2.000	+/-0.030	1,997"				
T	9.000	+/-0.010	9,000"				
U	9.000	+/-0.010	9,000"				
V	0.375	+/-0.010	,382"				

<b>Measured by:</b> J-F	<b>Audited by:</b> SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/03/30	<b>Date:</b> 06.03.30	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	



DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

REV. F  
SHEET 1 OF 2

SCALE

DATE

TITLE

1:6

A 95.10.31 NEW ISSUE

B 96.01.24 RE-DESIGN

C 96.03.26 CHANGE BORE AND C'BORE DEPTH

D 96.06.04 MOVE SLOT

E 97.02.27 CHANGE C'BORE DEPTH, BORE RADIUS

F 98.05.12 CHANGE C'BORE, ADD B AND F P/N

RELEASED  
98.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)  
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375

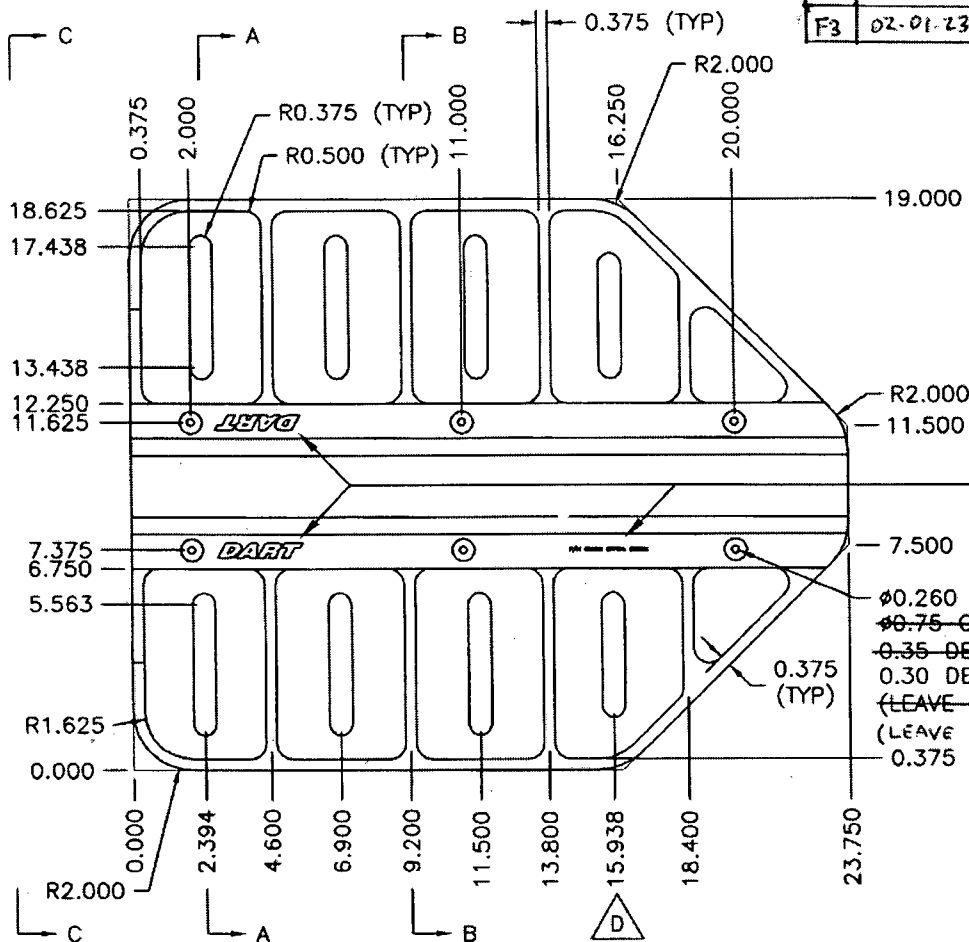
EFFECTIVE DEOS

9143

FLAT PATTERN

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



0.950 (REF)

BEND AFTER MACHINING  
(D2432B ONLY)

13.750

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ENGINEERING

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SUBJECT TO AMENDMENT

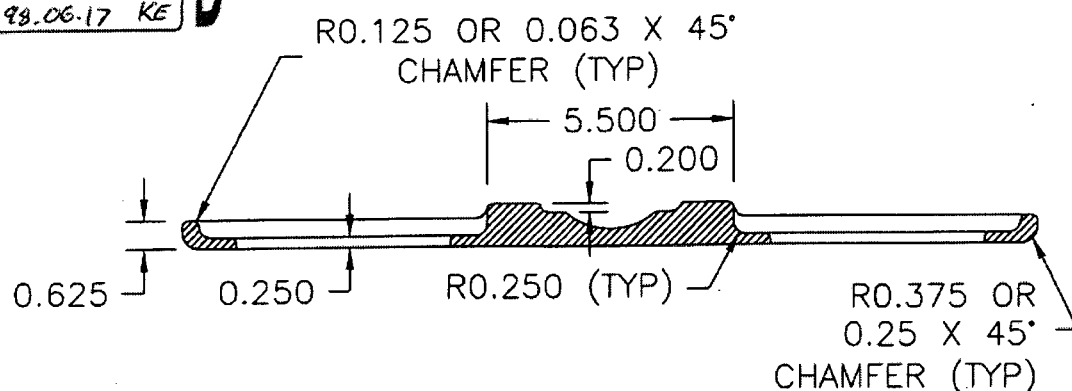
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WORK ORDER  
NO. 26076

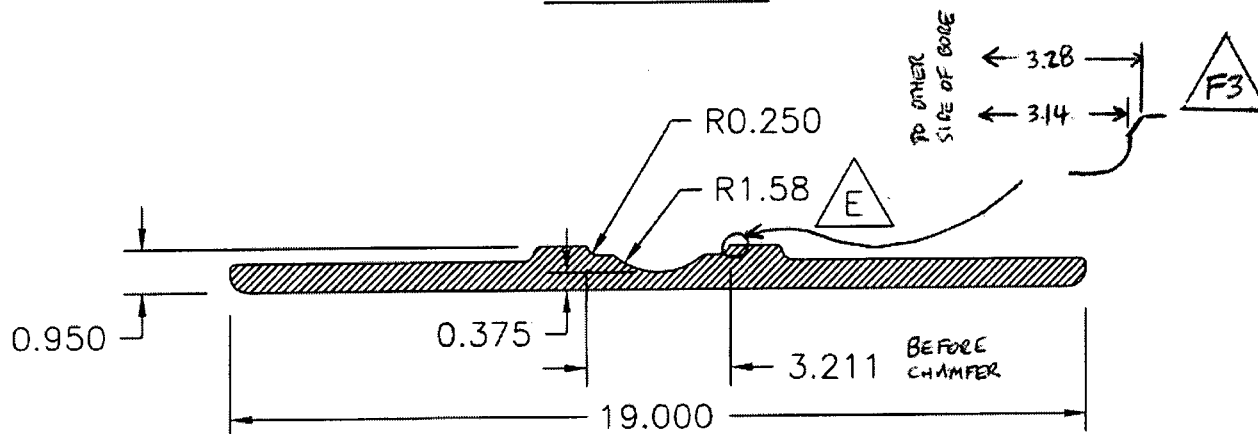


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

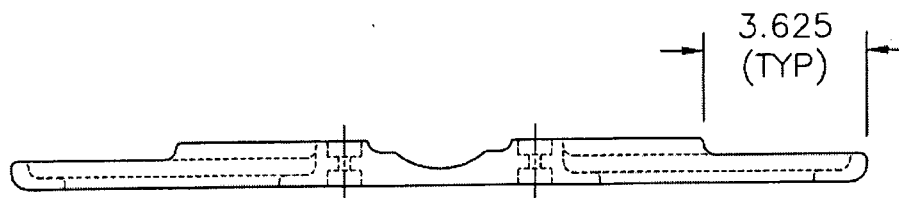
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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